

Date: Thursday, 20/11/2008 3:35:33 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 43629	
Estimate Number : 13549	
P.O. Number :	Part Number : D32341
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D3234 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 41251	Material :
Written By :	Due Date : 28/11/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 08.11.21</u>	
Comment : Est Rev:A New Issue 08-08-14 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.6080 sf(s)/Unit Total : 2.4318 sf(s)

2024-T3 .050 sheet

BATCH: 10711 IB 8-11-24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3234

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

IB 8-11-24

IB 8-11-24

(5)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-11-24

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/11/25 (75)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/11/25 (SX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:35:33 PM

User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 43629

Part Number: D32341

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(5x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/11/25

SC

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(5x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 237

8/11/25

SC

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

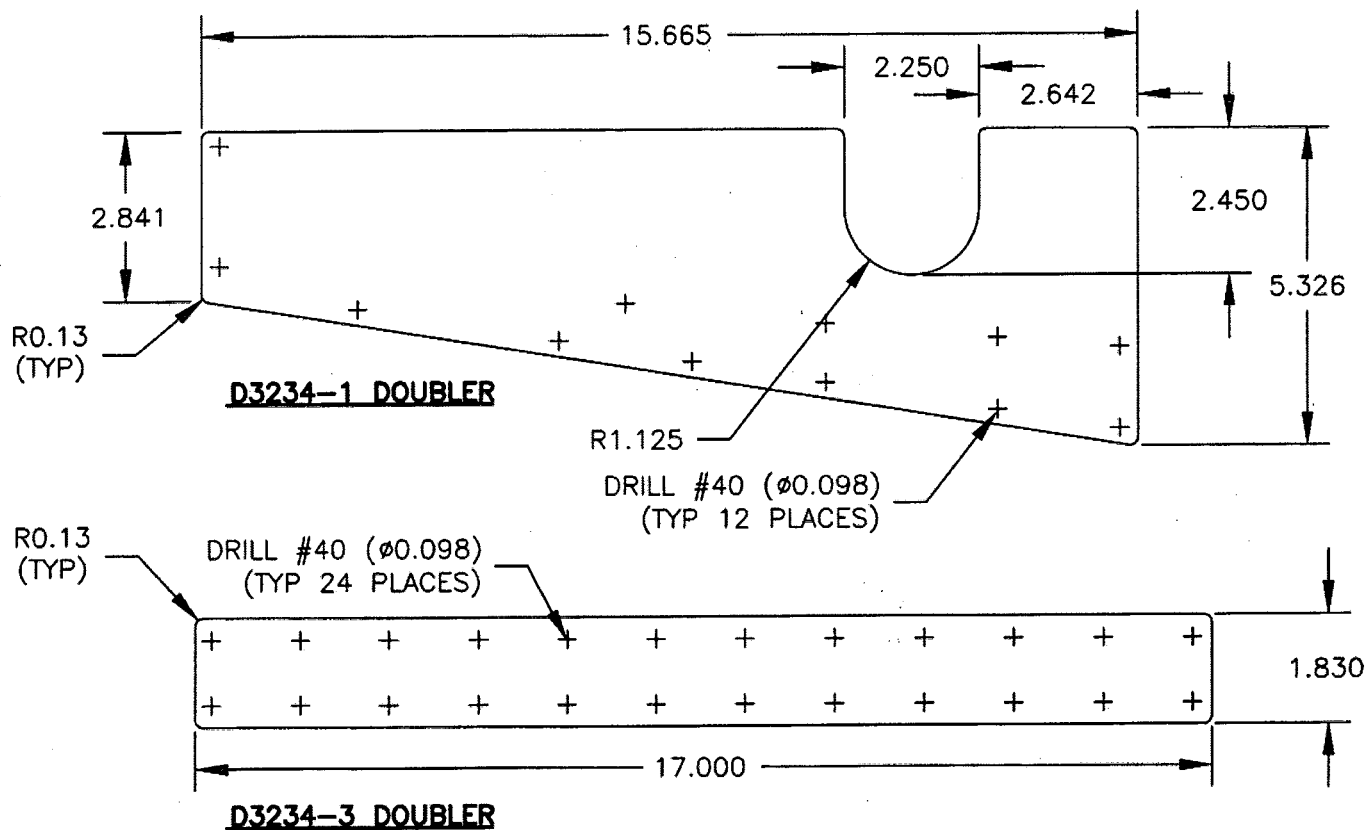
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

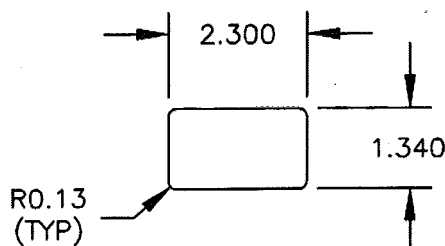


DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3234	REV. A SHEET 1 OF 1
DATE 03.11.19		TITLE DOUBLER	SCALE 1:3
A	03.11.19	NEW ISSUE	



RELEASED

03.11.24 [Signature]



D3234-5 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43629

D3234-1/-3 DOUBLER. D3234-5 SPACER

- 1) MACHINE PARTS PER DWG FILE "D3234-A.DWG"
- 2) MATERIAL: -1/-3: 2024-T3 (QQ-A-250/4), 0.050 THICK (REF DART SPEC. M2024T3S.050)
-5: 5052-H32 (QQ-A-250/8), 0.050 THICK (REF DART SPEC. M5052H32S.050)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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